

Date: Thursday, 9/20/2007 3:26:26 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE
Job Number : 34730	
Estimate Number : 12930	
P.O. Number : <i>N/A</i>	Part Number : D293220P <i>W</i>
This Issue : 9/20/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2932 REV C
Prsht Rev. : NC	Project -Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 34189	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/10/2007 Qty: 8 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.09.20	
Comment : Est Rev. A New Issue 07-07-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101003	7075-T7351 2X6.25X7.875
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

7075-T7351 2X6.25X7.875

Issue material from stock: 7075-T7351 (QQ-A-250/12)

Cut Size 2.0 x 6.25 X 7.88

Grain Along Long 7.88 Length

Batch No: *1334644x7*

B34106X1

ml 07/11/20

8

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Program part number and batch number.

1-Inspect part number and batch number are programmed correctly.

2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet

5-Deburr

ml 07/11/20

8

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE

Machine Keyway and inspect per attached dimension sheet

ml 07/11/20

8

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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Comment: INSPECT ALL DIM TO DIM SHEET

ml 07/11/20

8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AD Date: 07/11/26
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/20/2007 3:26:26 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE

Job Number: 34730

Part Number: D29322UP

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC 02.11.21

(8)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 07/11/21

(8)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/4/23

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 429

W

JS 07/11/23

(18)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/26
W 07/11/26

Job Completion



M 105914

(8)

L66 powder coat gloss white per DST005

BR 07-11-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34730
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.120	0.121	0.119	0.123		
B	0.100	0.140		0.119	0.121	0.120	0.120		
C	0.100	0.140		0.119	0.111	0.112	0.110		
D	0.210	0.230		0.220	0.223	0.222	0.222		
E	1.245	1.255		1.249	1.249	1.250	1.250		
F	1.245	1.255		1.250	1.249	1.250	1.250		
G	2.495	2.505		2.499	2.500	2.499	2.500		
H	0.510	0.515		0.510	0.510	0.510	0.510		
I	1.572	1.582		1.577	1.577	1.576	1.576		
J	2.495	2.505		2.497	2.497	2.496	2.497		
K	0.257	0.262		0.257	0.258	0.258	0.258		
L	0.312	0.317		0.313	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.239	0.238		
N	0.100	0.140		0.121	0.124	0.123	0.123		
O	0.540	0.560		0.549	0.548	0.548	0.547		
P	0.490	0.510		0.496	0.509	0.504	0.504		
Q	3.715	3.725		3.720	3.717	3.717	3.717		
R	2.470	2.510		2.493	2.497	2.492	2.492		
S	0.240	0.270		0.254	0.252	0.253	0.253		
T	0.100	0.180		0.145	0.142	0.142	0.142		
U	1.625	1.635		1.630	1.628	1.630	1.636		
V	1.362	1.372		1.367	1.366	1.366	1.366		
W	0.316	0.321		0.321	0.321	0.321	0.321		
X	1.125	1.145		1.135	1.133	1.132	1.133		
Y	1.565	1.585		1.572	1.5726	1.572	1.573		
Z	0.178	0.198		0.188	0.188	0.188	0.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	07/11/20

Audited by:	BC
Date:	07.11.21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	34730
Description: 206 Saddle, Outboard, Right side	Part Number:	D2932-2
Inspection Dwg: D2932 Rev. C		Page 1 of 1

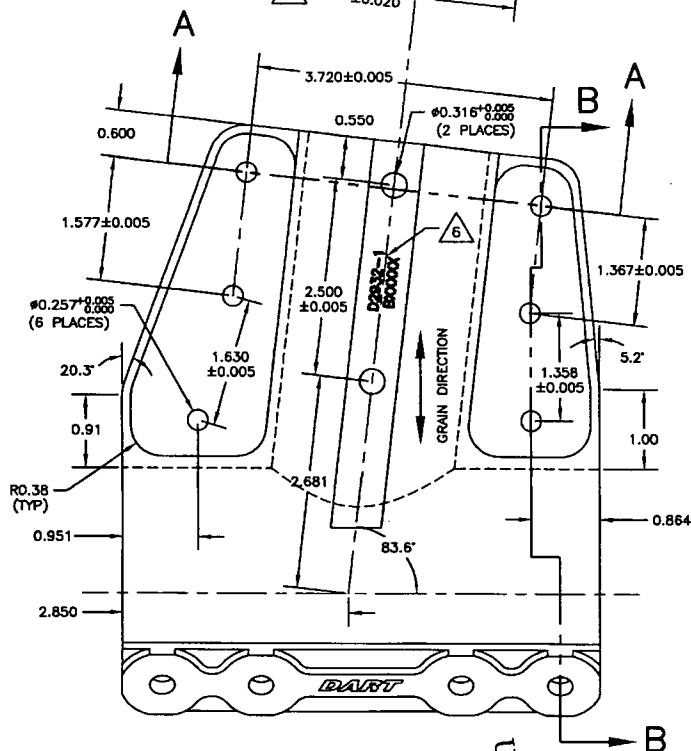
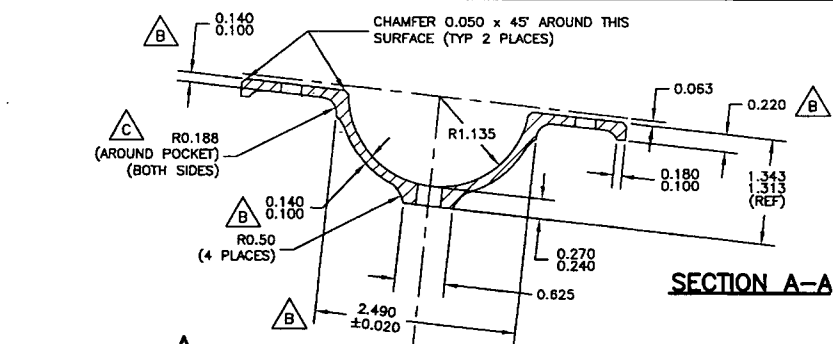
Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		0.120	0.119	0.118	0.118		
B	0.100	0.140		0.121	0.120	0.120	0.120		
C	0.100	0.140		0.113	0.112	0.111	0.112		
D	0.210	0.230		0.223	0.222	0.223	0.223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.499	2.499		
H	0.510	0.515		0.510	0.510	0.510	0.516		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.499	2.498	2.498	2.498		
K	0.257	0.262		0.259	0.258	0.258	0.258		
L	0.312	0.317		0.314	0.314	0.314	0.314		
M	0.235	0.240		0.238	0.238	0.238	0.238		
N	0.100	0.140		0.121	0.121	0.123	0.124		
O	0.540	0.560		0.546	0.549	0.550	0.546		
P	0.490	0.510		0.503	0.502	0.502	0.503		
Q	3.715	3.725		3.718	3.717	3.718	3.718		
R	2.470	2.510		2.492	2.493	2.493	2.493		
S	0.240	0.270		0.257	0.253	0.252	0.250		
T	0.100	0.180		0.140	0.142	0.142	0.142		
U	1.625	1.635		1.630	1.628	1.628	1.628		
V	1.362	1.372		1.367	1.365	1.366	1.366		
W	0.316	0.321		0.321	0.320	0.320	0.320		
X	1.125	1.145		1.133	1.133	1.135	1.135		
Y	1.565	1.585		1.571	1.571	1.572	1.573		
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

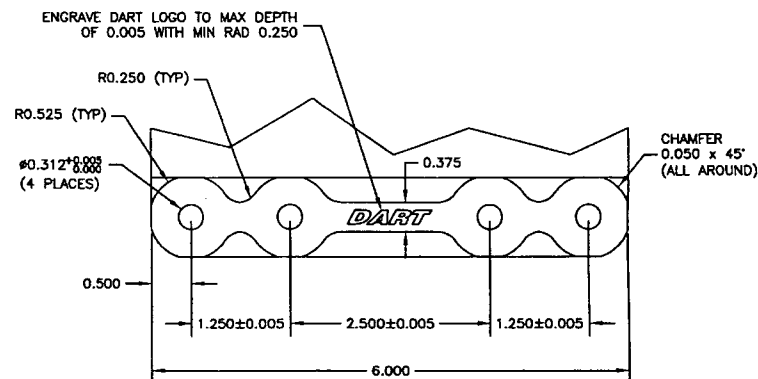
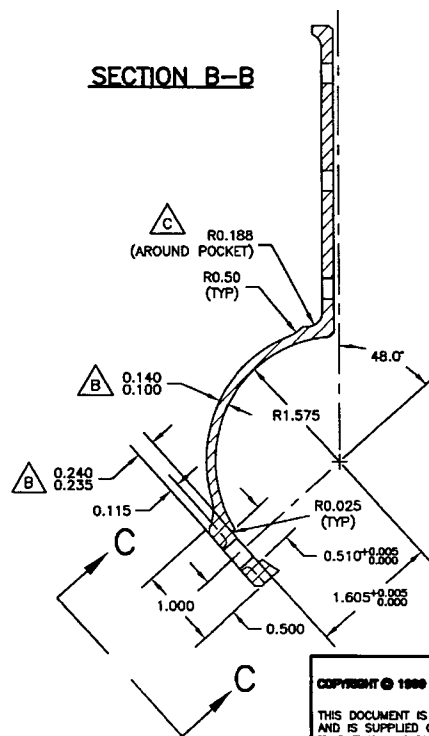
Measured by:	JNL
Date:	07/11/20

Audited by:	RF
Date:	07-11-21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)

D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLINGHAM, WA
CHECKED	APPROVED	DRAWING NO. D2932
DATE		TITLE SADDLE OUTSIDE
06.11.09		REV. C SHEET 1 OF 1 SCALE 2:3

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07-02-12

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